

# Work Order ID 72884

Wednesday, August 17, 2011 2:42:32 PM



Page 1

Item ID: D2933-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle LH In. 206

Start Date: 8/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date: 11-08-17 Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr Revision Nbr

D2933 Rev C

100

0.00



HAAS CNC VERTICAL MACHINING #1

0.00

HAAS 1

Memo

HAAS CNC vertical machine #1

Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2933 & attached Dimension Sheet 1 3-Machine Step No 2 of Folio and visually inspect as per

110

0.00



CONVENTIONAL MILLING MACHINE

0.00

Mill Conv

Memo

Conventional Milling Machine

Machine Keyway and inspect per attached dimension sheet

120

0.00



QC1- Inspect dimensions to dimension sheet

0.00

QC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Item Name: Saddle LH In, 206

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Start Date: 8/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:  
QC: Date: SPC (Y/N): Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

SL 11-08-23



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

2:45  
3:15

320 °F

6X Ø m-11/08/24

6X Ø m-11/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 72884

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Page 3

Item ID: D2933-1

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Setup Start



Revision ID:

Stop



Item Name: Saddle LH In, 206

Start Date: 8/17/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

6 BR 11-8-24.

170

Identify as per dwg & Stock Location: ST428

0.00



Packaging

Memo

0.00

Packaging

SP

6x SP 11-08-25

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/25

CL 11/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, August 17, 2011 2:42:38 PM

Page 1  
T

Work Order ID: 72884



Parent Item: D2933-1



Parent Item Name: Saddle LH In, 206

Start Date: 8/17/2011

Required Date: 8/25/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: B100.06.261 New DWG rev (mpp 2069) ECI  
IPP Rev: C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001 		Manufactured	No			100	Each	73.0000	1	6			

Saddle Billet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT040	73	
64777	20	
66965	1	
69677	2	
70976	10	
✓72225	40	

6.000 B.A 11/08/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>				<b>Work Order:</b> 72884	
<b>Description:</b> 206 Saddle, Inboard, Left side				<b>Part Number:</b> D2933-1	
<b>Inspection Dwg:</b> D2933 <b>Rev:</b> C <b>DSK:</b> <b>Rev:</b>				<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION DIMENSION SHEET

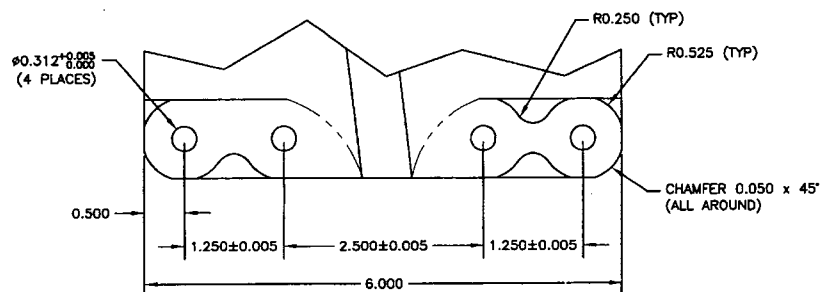
☒ First Article
 ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge ①	②	③	④	⑤	⑥
A	0.100	0.140	.109	.109	.108	.108	.109	.109
B	0.100	0.140	.111	.107	.108	.105	.106	.104
C	0.100	0.140	.116	.117	.118	.118	.118	.118
D	0.210	0.230	.220	.219	.218	.218	.218	.219
E	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250
F	1.245	1.255	1.250	1.250	1.250	1.250	1.250	1.250
G	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500
H	0.510	0.515	.501	.570	.570	.570	.570	.570
I	1.572	1.582	1.578	1.578	1.578	1.578	1.578	1.578
J	2.495	2.505	2.500	2.500	2.500	2.500	2.500	2.500
K	0.257	0.262	.258	.258	.258	.258	.258	.258
L	0.312	0.317	.314	.314	.314	.314	.314	.314
M	0.235	0.240	.236	.236	.237	.237	.238	.237
N	0.100	0.140	.111	.111	.111	.111	.110	.111
O	0.540	0.560	.550	.557	.549	.550	.548	.546
P	0.490	0.510	.501	.501	.502	.503	.502	.501
Q	3.715	3.725	3.719	3.719	3.719	3.720	3.720	3.720
R	2.470	2.510	2.490	2.490	2.490	2.490	2.490	2.490
S	0.240	0.270	.250	.249	.251	.249	.251	.249
T	0.100	0.180	.132	.134	.135	.135	.135	.135
U	1.625	1.635	1.630	1.630	1.630	1.630	1.630	1.630
V	1.362	1.372	1.368	1.368	1.368	1.368	1.368	1.368
W	0.316	0.321	.316	.316	.316	.317	.317	.317
X	1.125	1.145	1.1342	1.134	1.1335	1.132	1.131	1.133
Y	1.565	1.585	1.572	1.571	1.5725	1.572	1.571	1.573
Z	0.178	0.198	.188	.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								
Accept/Reject								

<b>Measured by:</b> <i>mx</i>	<b>Date:</b> 11/08/23
<b>Audited by:</b> <i>sl</i>	<b>Date:</b> 11-08-23
<b>Prototype Approval:</b> N/A	<b>Date:</b> N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	



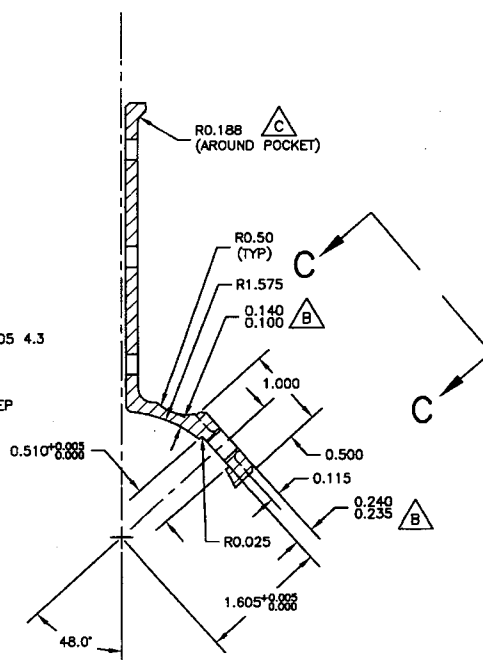


VIEW C-C

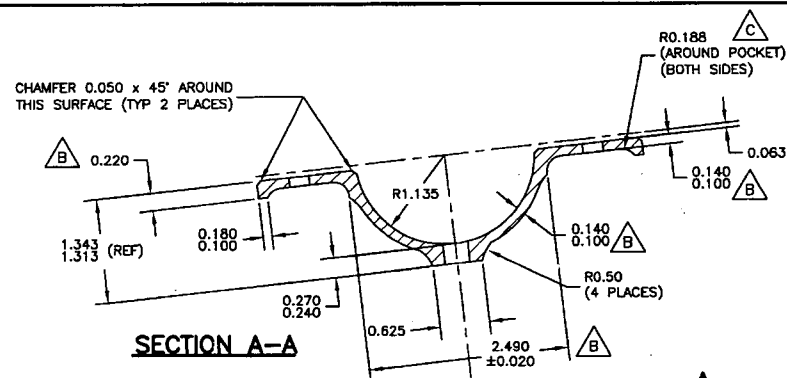
D2933-1 LH SADDLE (SHOWN)  
D2933-2 RH SADDLE (OPPOSITE)

NOTES:

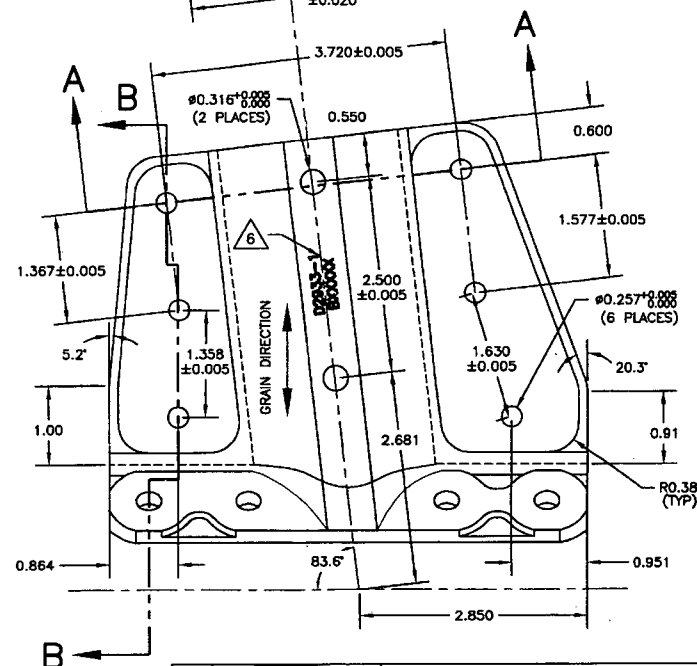
- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP



SECTION B-B



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	CB	DART AEROSPACE USA, INC. BELLVALE, MI
CHECKED	PH	DRAWING NO. D2933
DATE	06.11.09	TITLE SADDLE INSIDE
		REV. C SHEET 1 OF 1 SCALE 2:3

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RELEASED

07-02-12

